

Date: Thursday, 3/9/2006 8:27:18 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SHROUD ASSEMBLY
<b>Job Number</b> :	26166		
<b>Estimate Number</b> :	12226		
<b>P.O. Number</b> :	NIA	<b>Part Number</b> :	D3467041
<b>This Issue</b> :	3/9/2006	<b>Drawing Number</b> :	D3467 REV A
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	NIA	<b>Drawing Revision</b> :	A
<b>Previous Run</b> :	NIA	<b>Material</b> :	NIA
	<b>Type</b> :	<b>Due Date</b> :	3/30/2006
	SMALL /MED FAB	<b>Qty:</b>	1
<b>Written By</b> :	<i>SEE COMMENT BELOW</i>		<b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<i>SEE ABOVE USER &amp; DATE</i>		
<b>Comment</b> :	Est Rev: A New Issue 06-02-03 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D3467047	COVER PLATE ASSEMBLY, LH
-----	----------	--------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-047	cover lh	<u>B26261</u>

*AB 0603-30①*

2.0	D3467048	COVER PLATE ASSEMBLY, RH
-----	----------	--------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-048	cover rh	<u>B26294</u>

*AB 0603-30①*

3.0	D3467045	BAFFLE & DEFLECTOR ASSEMBLY
-----	----------	-----------------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-045	BAFFLE & DEFLECTOR ASSEMBLY	<u>B26262</u>

*AB 0603-30①*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/9/2006 8:27:18 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26166

Part Number: D3467041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

4.0	D3467043	FWD PLATE ASSEMBLY
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3467-043	Fwd Plate Ass

Batch

B26263

B0603-30 ①

5.0	NAS679A3	NUT SELF LOCK
-----	----------	---------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description
8	NAS679A3	Nut

Batch

M19467

B0603-30 ①

6.0	AN96010	Washer
-----	---------	--------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty	Part Number	Description
18	AN960-10	Washer

Batch

M5519

B0603-30 ①

7.0	AN33A	Bolt
-----	-------	------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty	Part Number	Description
18	AN3-3A	Bolt

Batch

M100117

B0603-30 ①

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467  
Identify as D3467-041

B0603-30 ①

9.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

B0603-30 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/13

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/9/2006 8:27:18 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26166

Part Number: D3467041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*0603.30*

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*0603.31*

Job Completion



*0603.30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

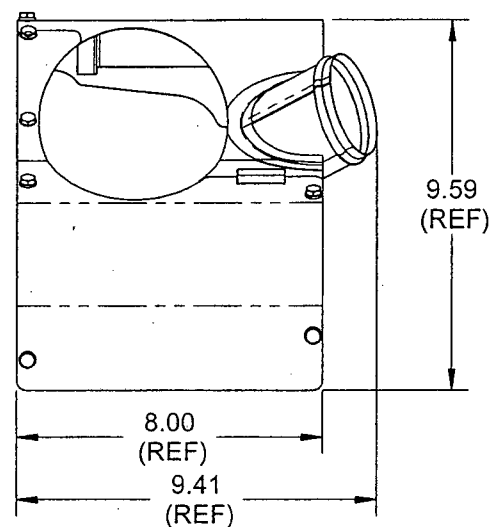
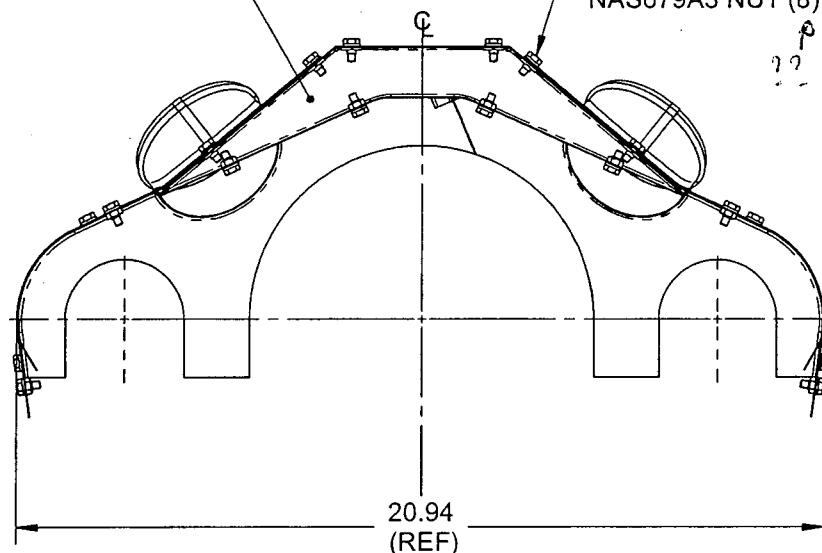
PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3467	REV. A SHEET 1 OF 15
DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:5
A	05.12.07	NEW ISSUE	

D3467-043 FWD  
PLATE ASS'Y (1)

AN3-3A BOLT (18)  
AN960-10 WASHER (18)  
NAS679A3 NUT (8)

MAT'L CORN



PARTS LIST

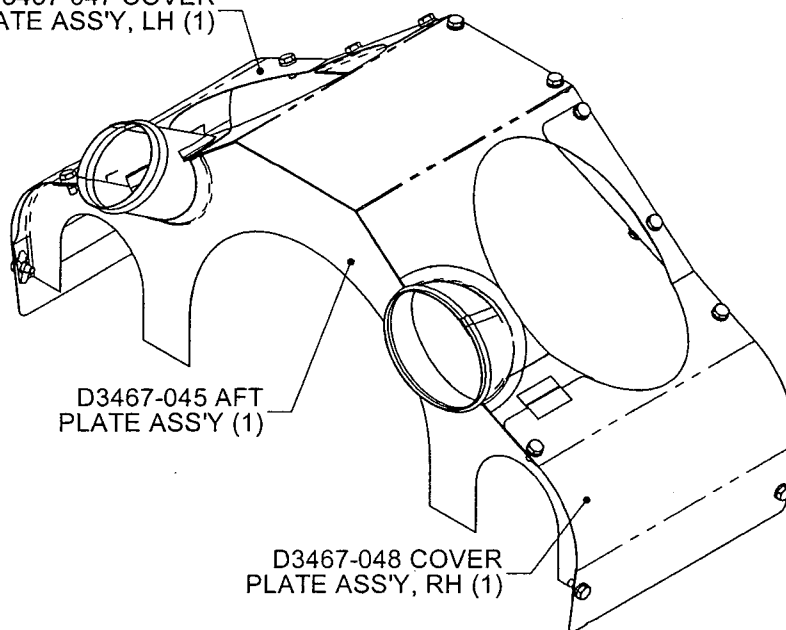
	P/N	DESCRIPTION
x	D3467-041	SHROUD ASSEMBLY
1	D3467-043	
1	D3467-045	
1	-047	
1	-048	
18		BOLT
18		WASHER
18		NUT

**D3467-041 SHROUD ASSEMBLY**

**NOTES:**

- 1) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

D3467-047 COVER  
PLATE ASS'Y, LH (1)



D3467-045 AFT  
PLATE ASS'Y (1)

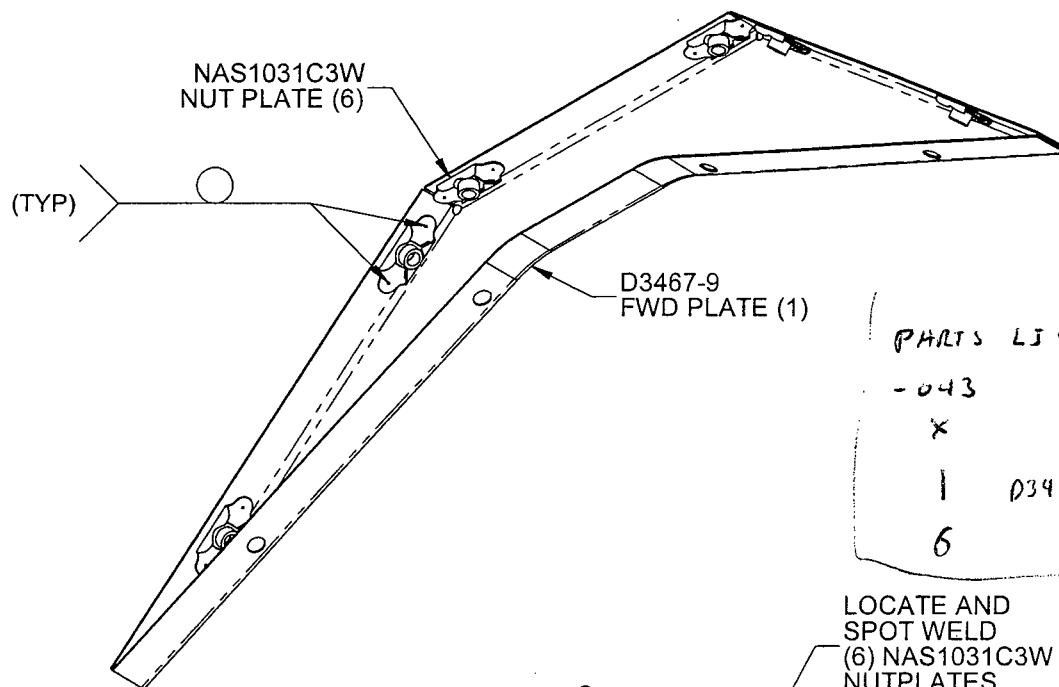
D3467-048 COVER  
PLATE ASS'Y, RH (1)

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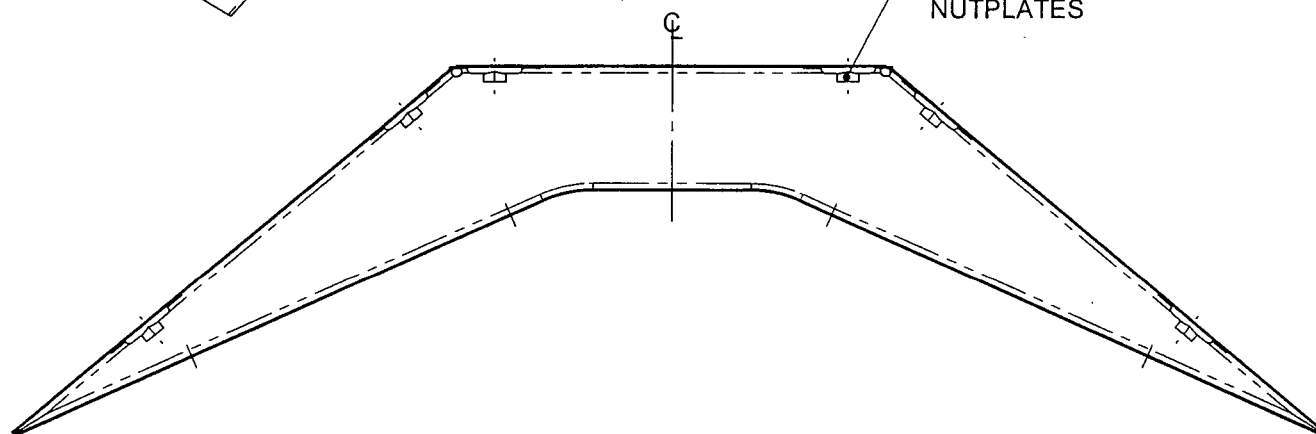
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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2



**PARTS LIST**  
- 043  
X  
1 D3467A FWD  
6 NUT PLATE

LOCATE AND  
SPOT WELD  
(6) NAS1031C3W  
NUTPLATES



## D3467-043 FWD PLATE ASSEMBLY

### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) ASSEMBLY IS SYMETRICAL ABOUT CENTER LINE
- 3) FINISH: ELECTRO CHEMICALLY POLISH
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

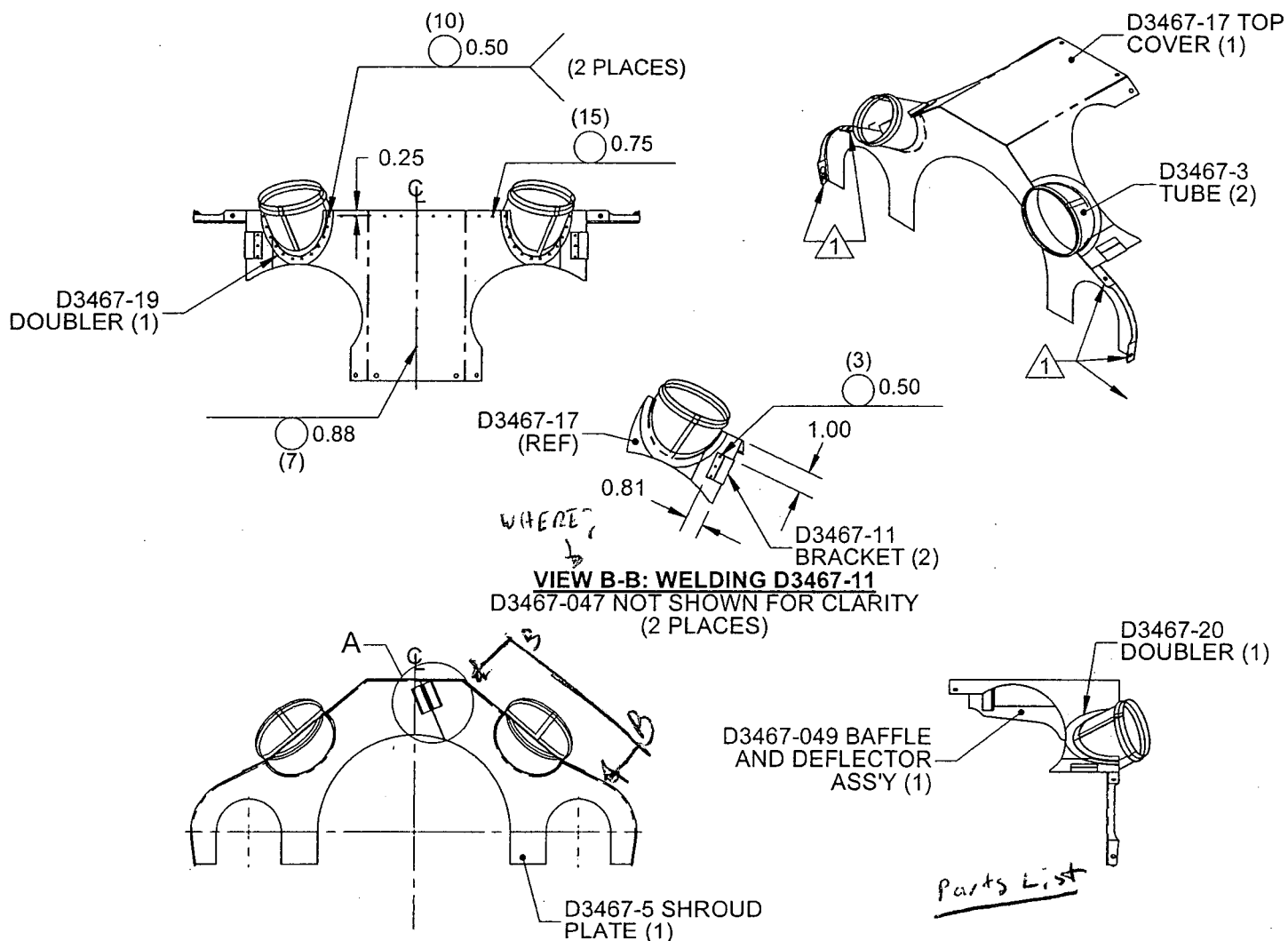
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	
		SCALE 1:8	



## D3467-045 AFT PLATE ASSEMBLY

### NOTES:

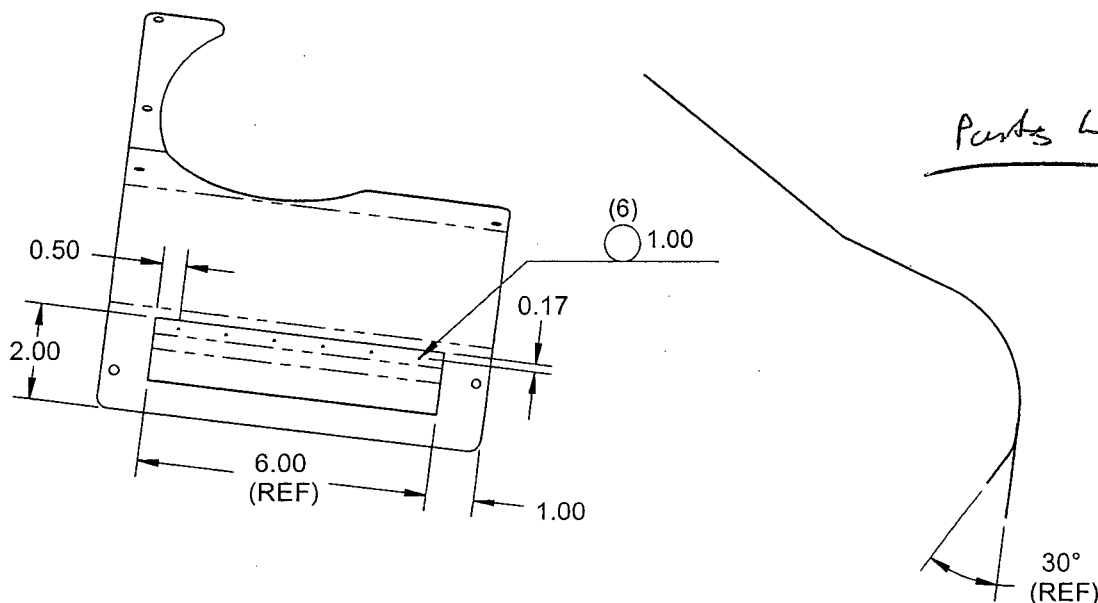
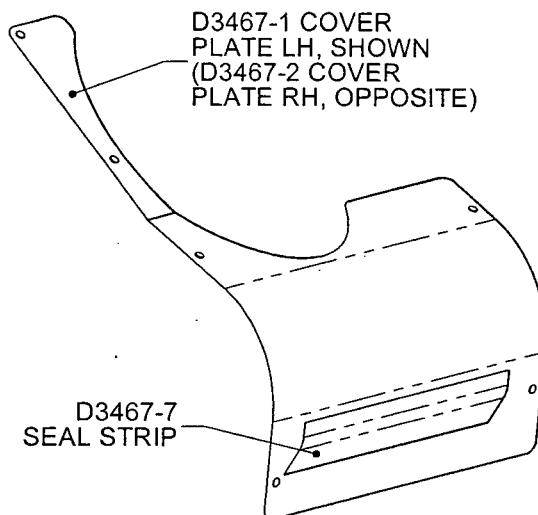
- 1) LOCATE AND SPOT WELD NAS1031CW NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO 3467-5 *7- D3467-5*
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: ELECTRO-CHEMICALLY POLISH
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED	APPROVED	DRAWING NO. D3467	REV. A SHEET 4 OF 15
DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:4



**D3467-047 COVER PLATE ASS'Y LH, SHOWN**  
**D3467-048 COVER PLATE ASS'Y RH, OPPOSITE**

**NOTES:**

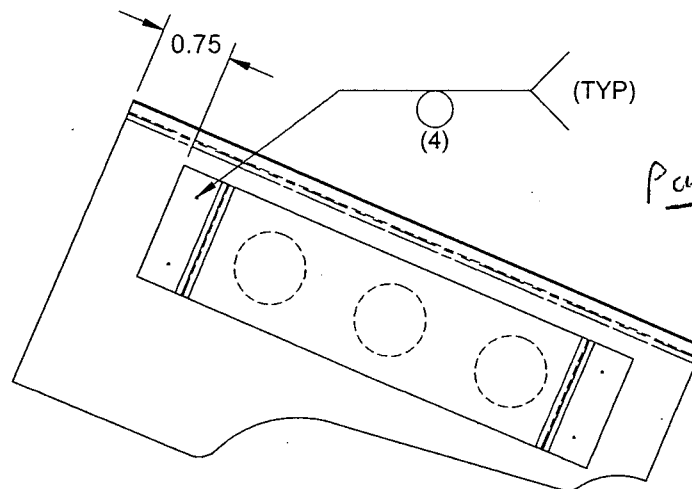
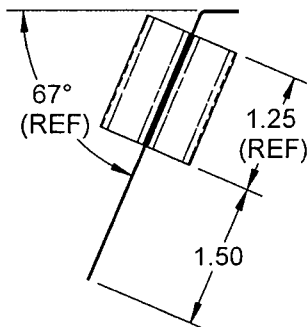
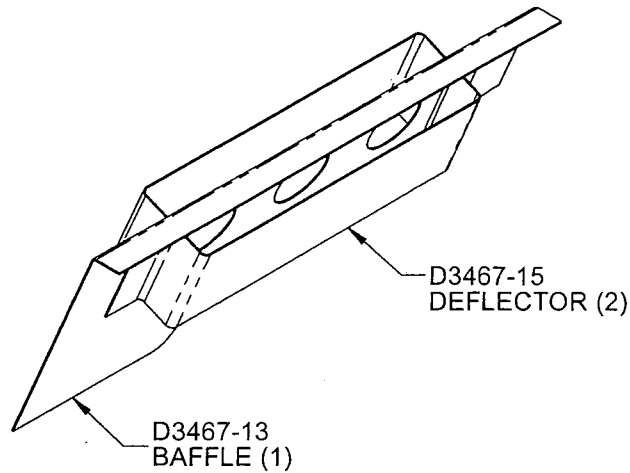
- 1) WELD PER DART QSI 004
- 2) FINISH: ELECTRO CHEMICALLY POLISHED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2



### D3467-049 BAFFLE & DEFLECTOR ASSEMBLY

#### NOTES:

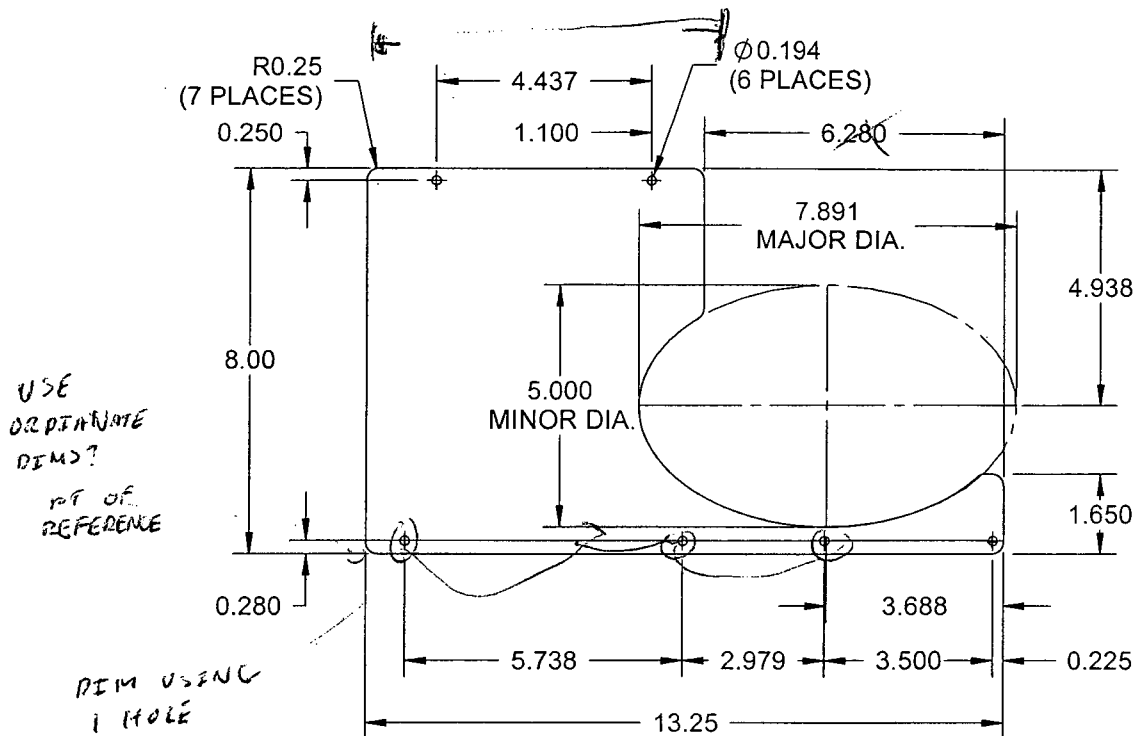
- 1) SPOT WELD PER DART QSI 004
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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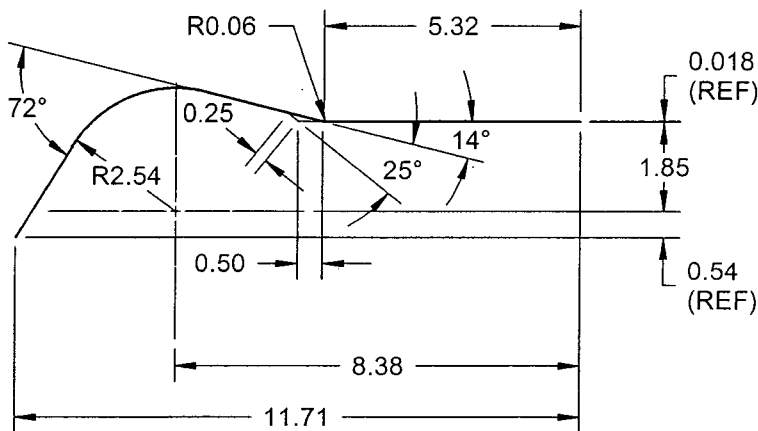
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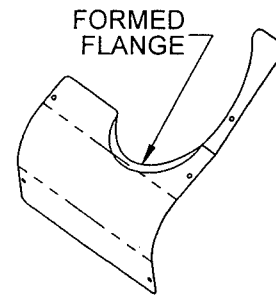
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:4



**D3467-1F COVER PLATE FLAT PATTERN**



**D3467-1 LH COVER PLATE  
D3467-2 RH COVER PLATE (OPPOSITE)**



**D3467-1 LH COVER PLATE ISOMETRIC VIEW,  
D3467-2 RH COVER PLATE (OPPOSITE)  
SCALE 1:8**

**NOTES:**

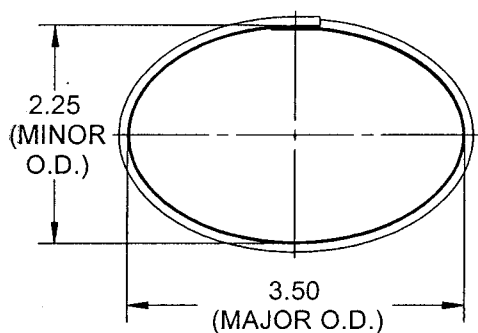
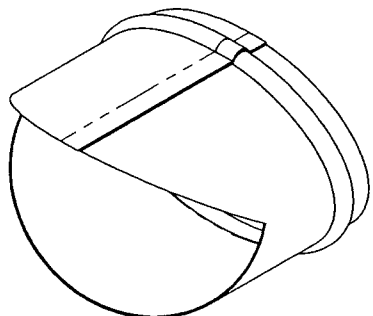
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: ELECTRO CHEMICALLY POLISH
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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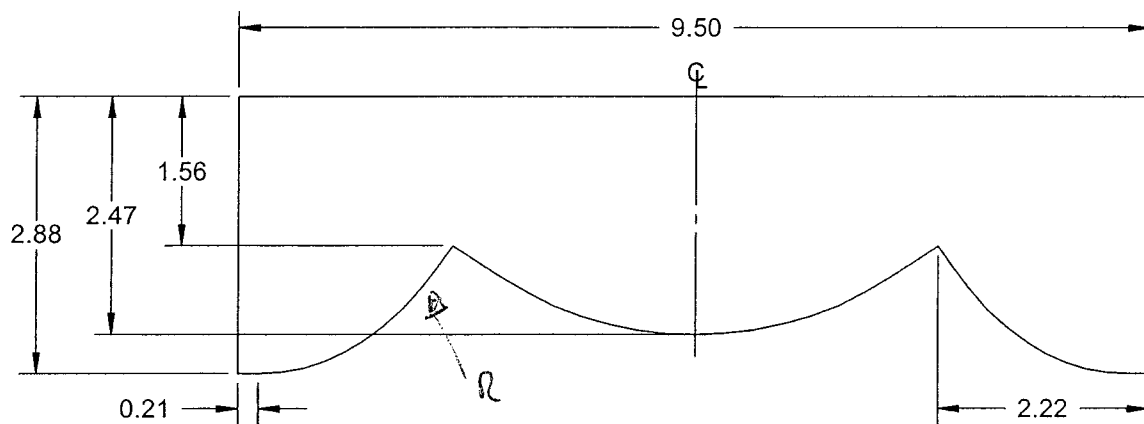
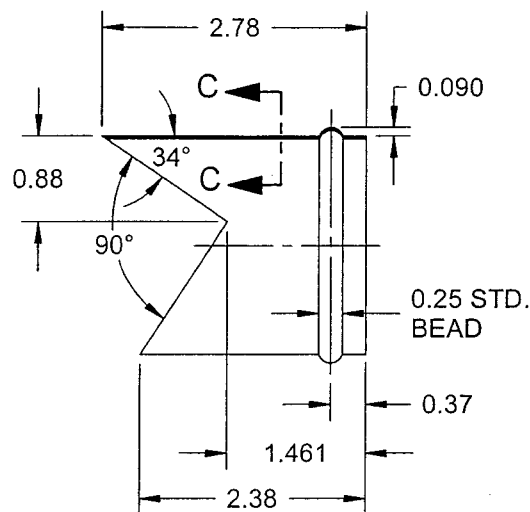
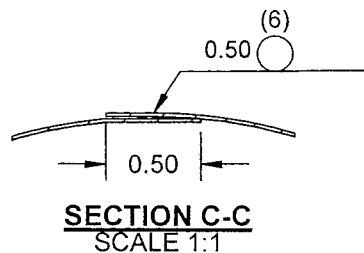
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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:2



**D3467-3 TUBE DETAIL**



**D3467-3F TUBE FLAT PATTERN**

**NOTES:**

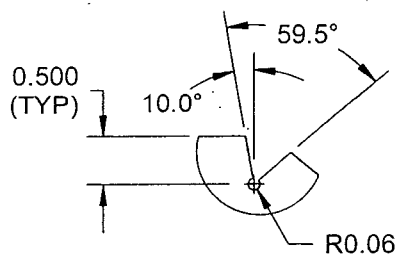
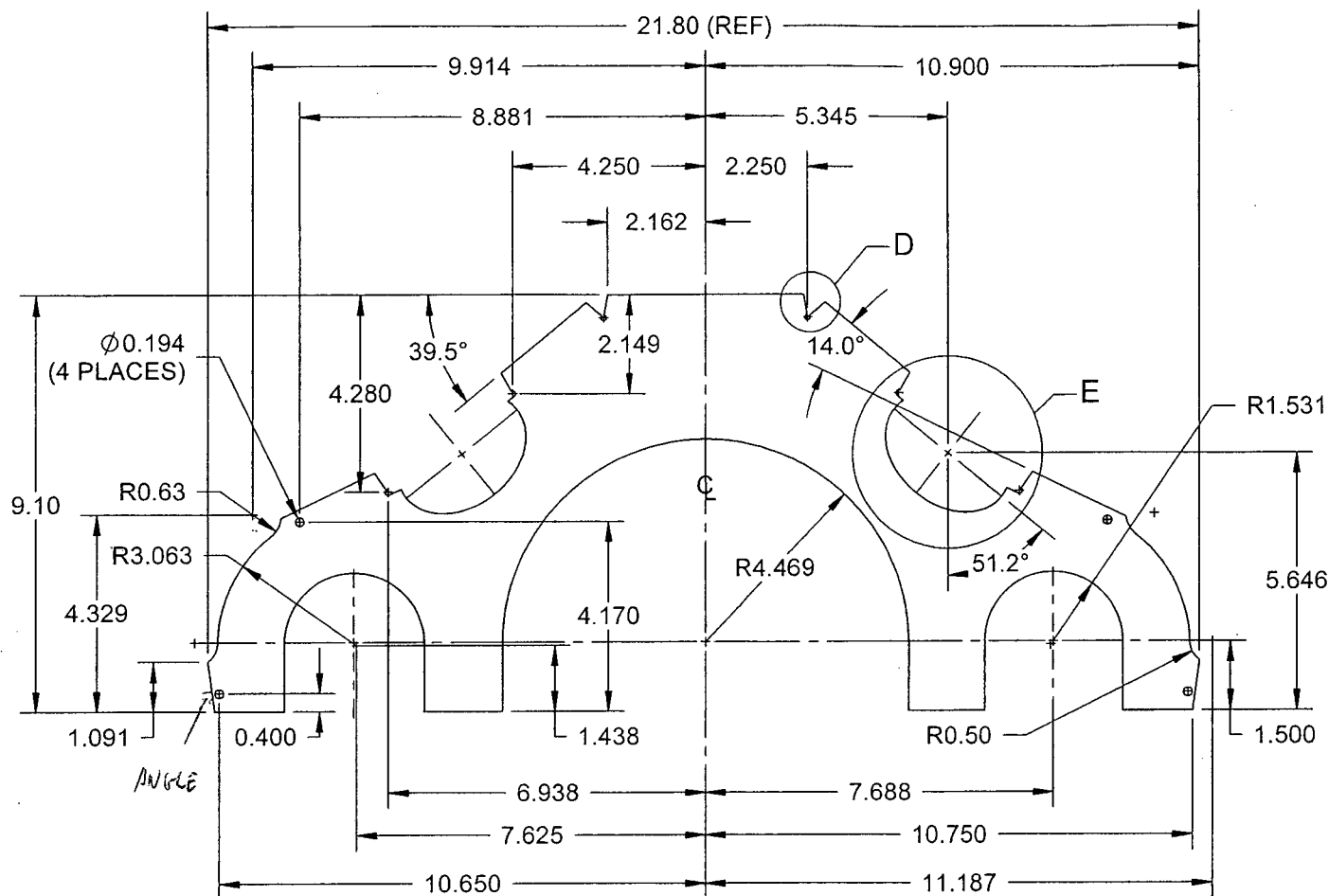
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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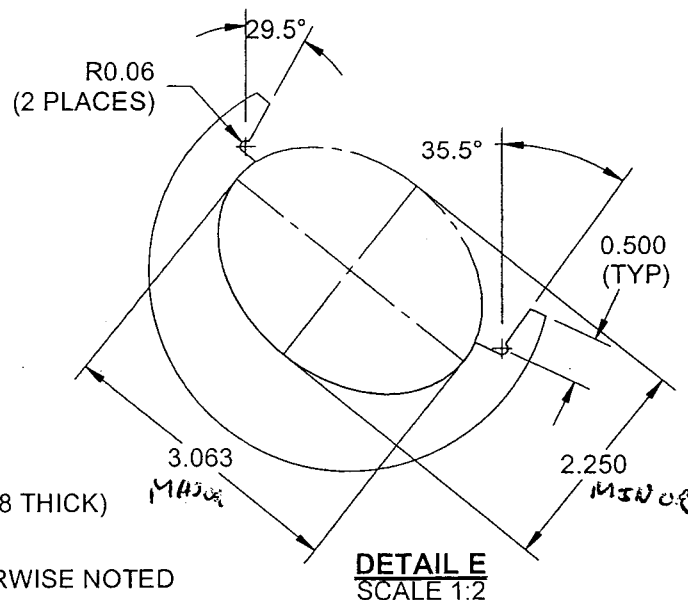
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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:8



**DETAIL D**  
SCALE 1:2



**DETAIL E**  
SCALE 1:2

## D3467-5F AFT PLATE FLAT PATTERN



### NOTES:

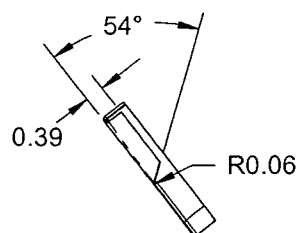
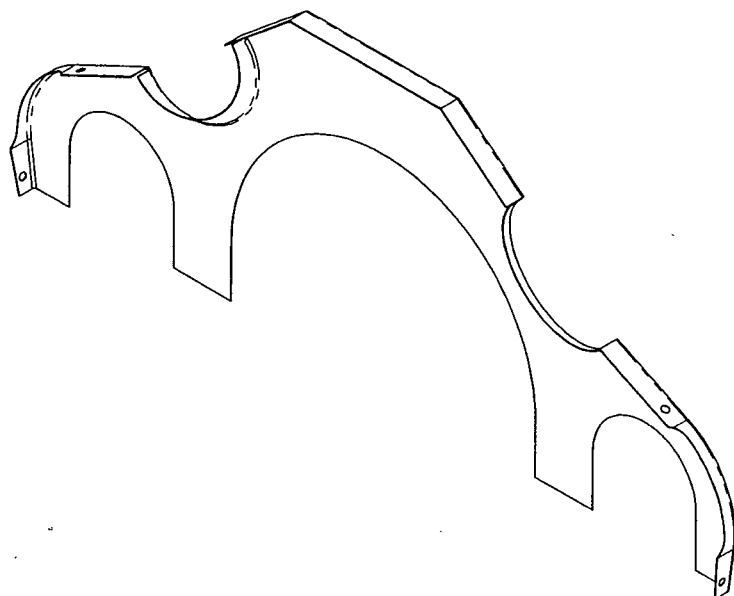
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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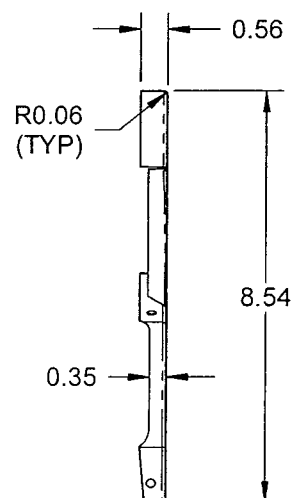
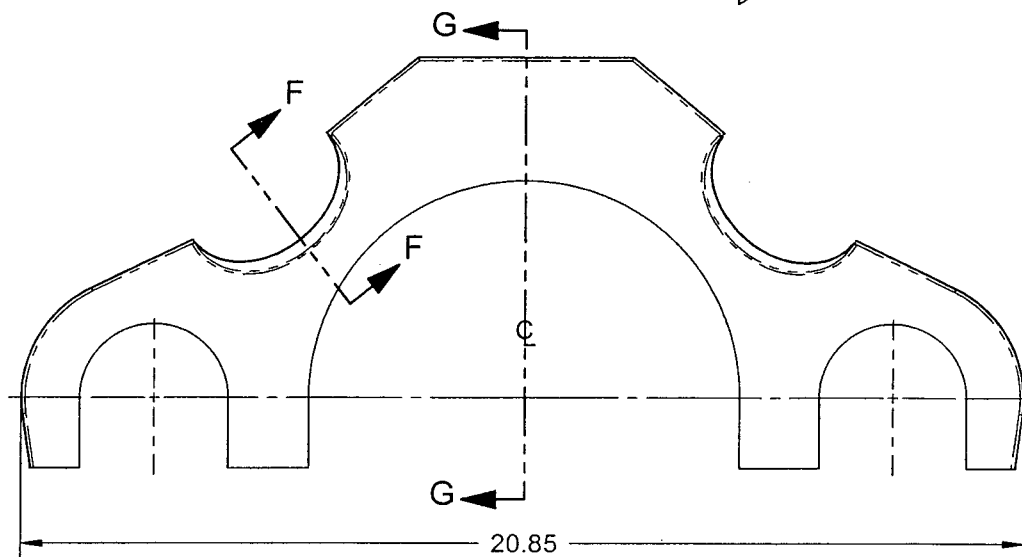
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CHECKED	APPROVED	DRAWING NO. D3467	REV. A SHEET 9 OF 15
DATE 05.12.06	TITLE SHROUD ASSEMBLY		SCALE 1:4



**SECTION F-F**



**SECTION G-G**

**D3467-5 AFT PLATE BENDING DETAIL**

**NOTES:**

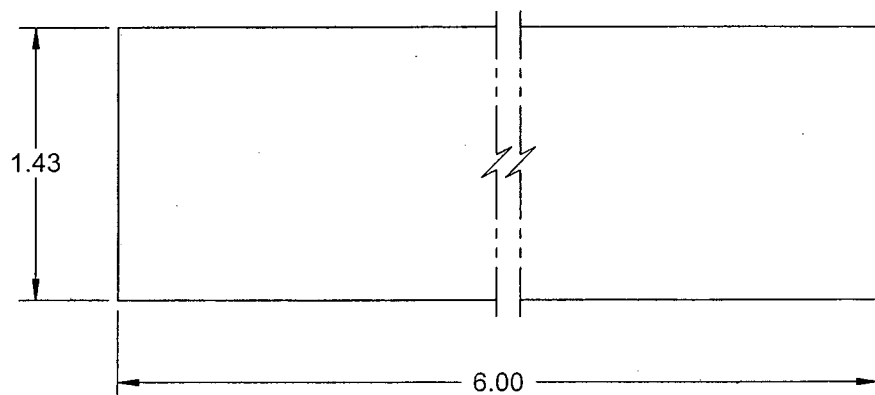
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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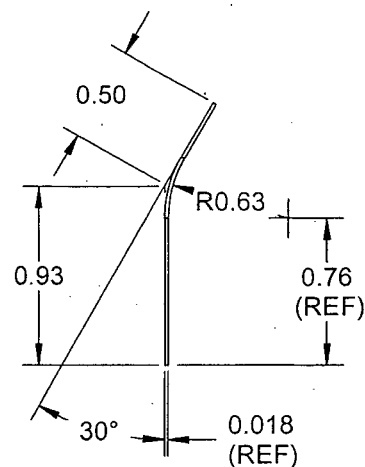
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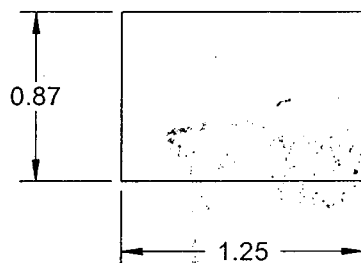
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CHECKED	APPROVED	DRAWING NO. D3467	REV. A SHEET 10 OF 15
DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:1



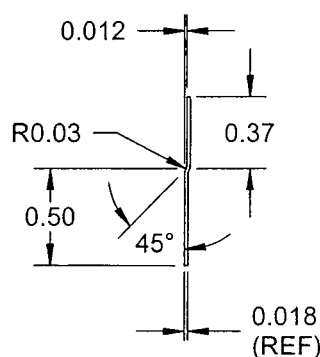
**D3467-7F SEAL STRIP  
FLAT PATTERN**



**D3467-7 SEAL STRIP  
BENDING DETAIL**



**D3467-11F BRACKET  
FLAT PATTERN**



**D3467-11 BRACKET  
JOGGLE DETAIL**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

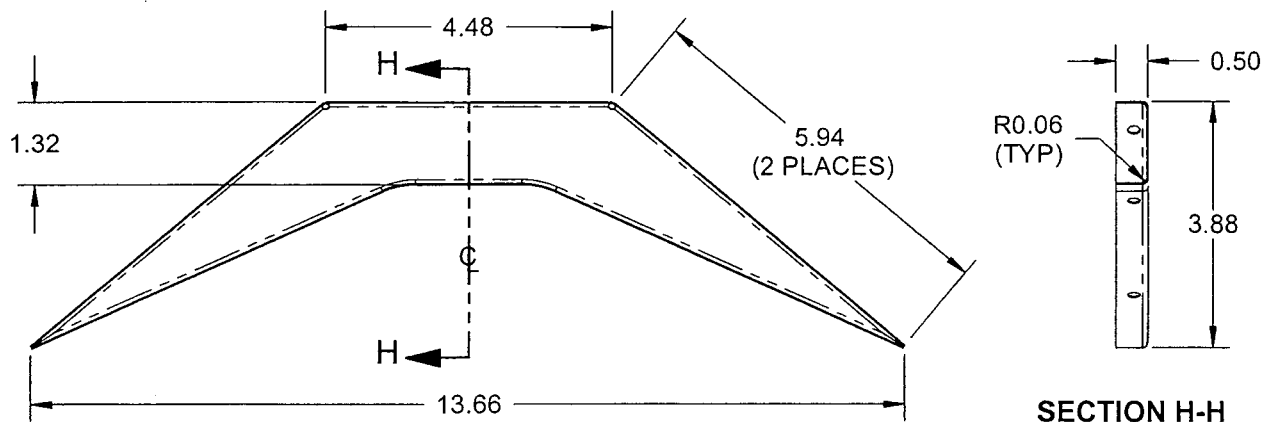
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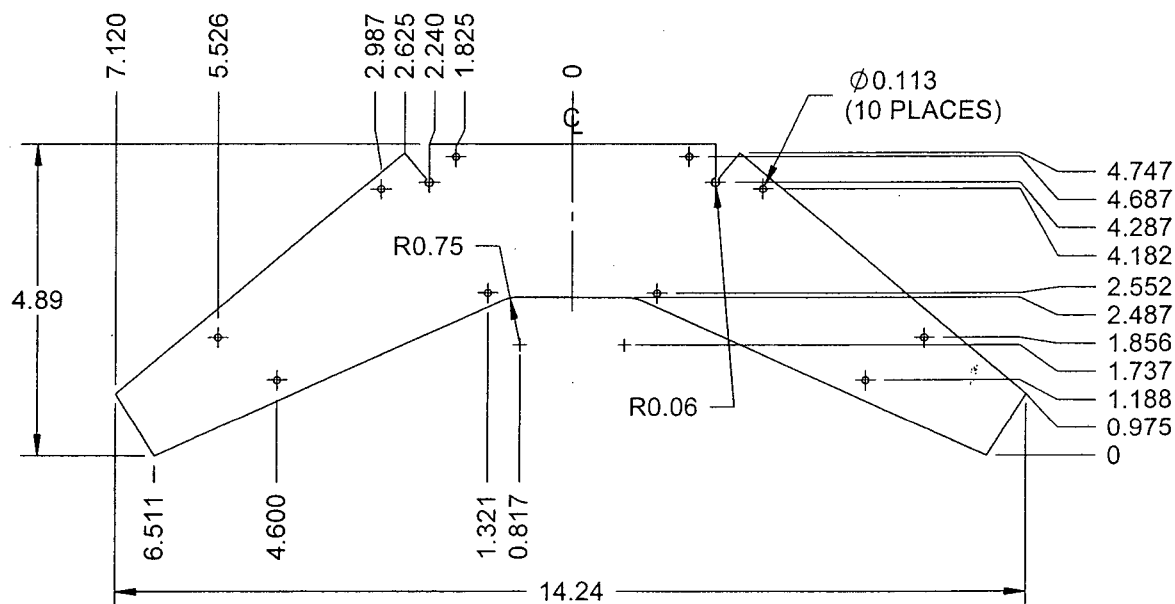


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DATE <b>05.12.07</b>		TITLE <b>SHROUD ASSEMBLY</b>	SCALE 1:3



**D3467-9 FWD PLATE BENDING DETAIL**



**D3467-9F FWD PLATE FLAT PATTERN**

**NOTES:**

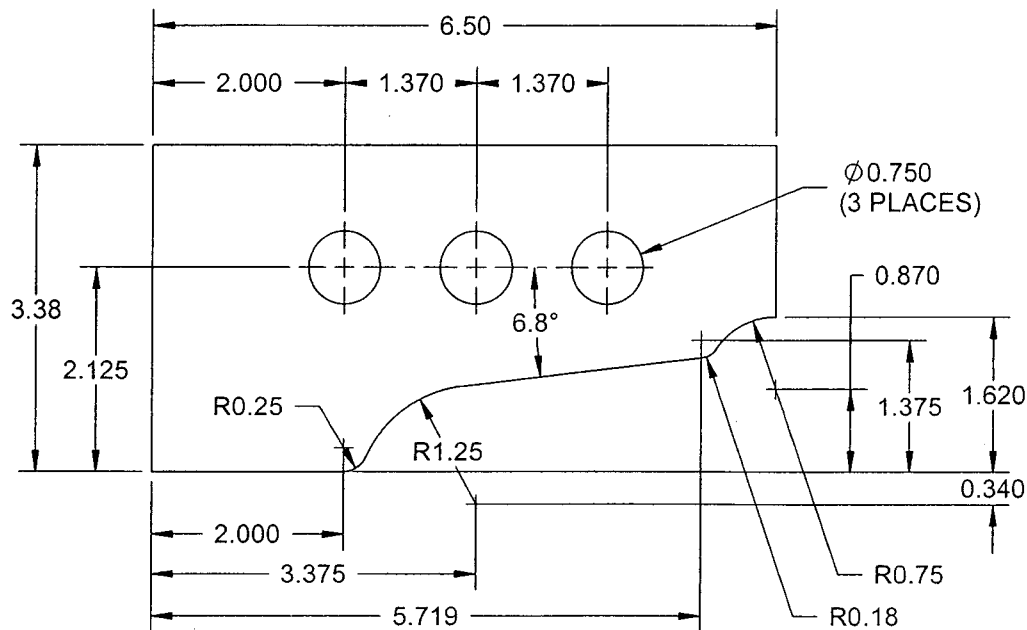
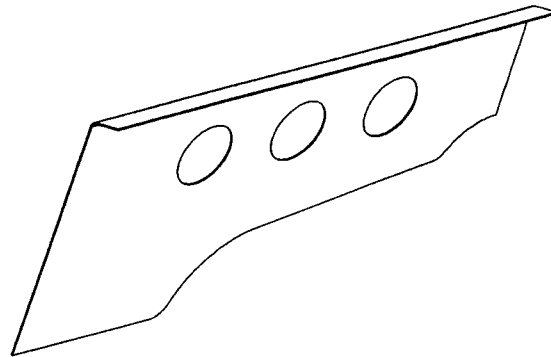
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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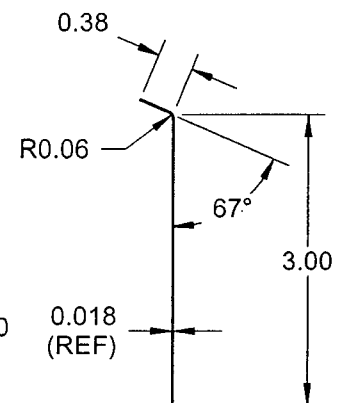
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DATE 05.12.07	TITLE SHROUD ASSEMBLY		SCALE 1:2



**D3467-13F BAFFLE  
FLAT PATTERN**



**D3467-13 BAFFLE  
BEND DETAIL**

**NOTES:**

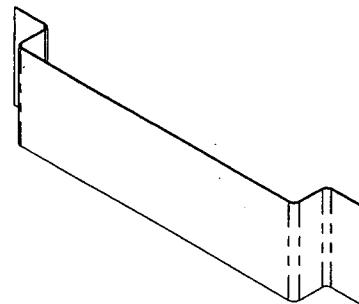
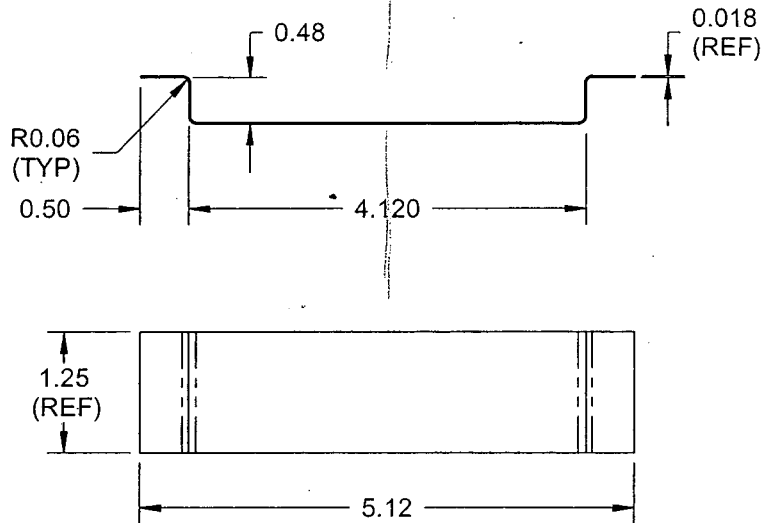
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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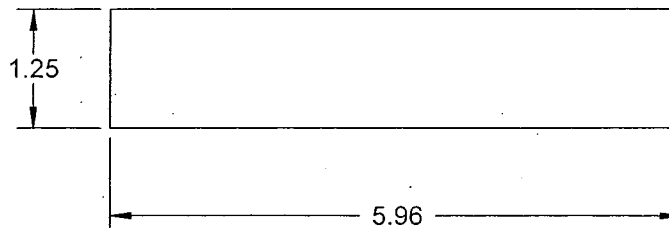
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2



#### D3467-15 DEFLECTOR BENDING DETAIL



#### D3467-15F DEFLECTOR FLAT PATTERN

##### NOTES:

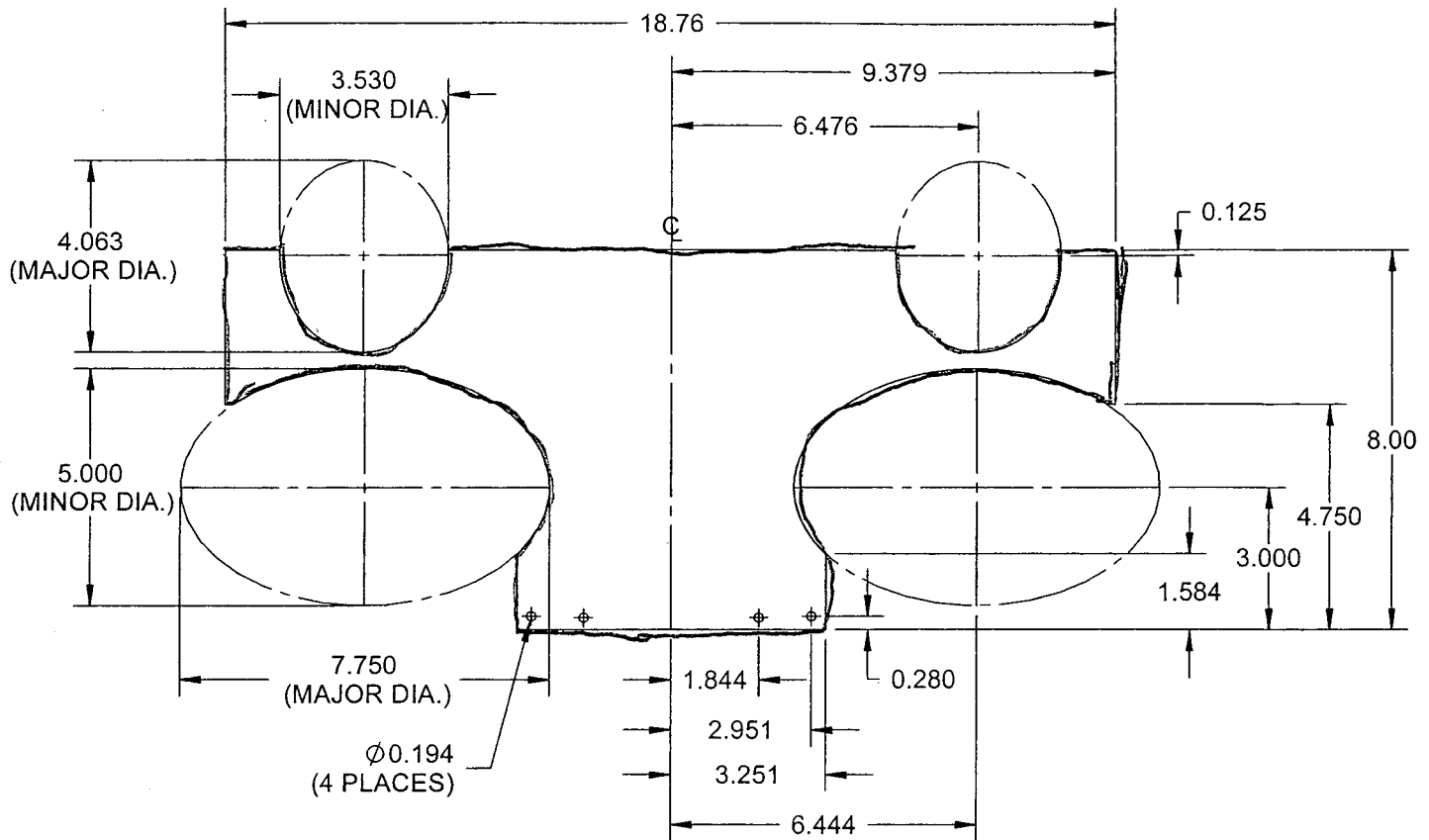
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
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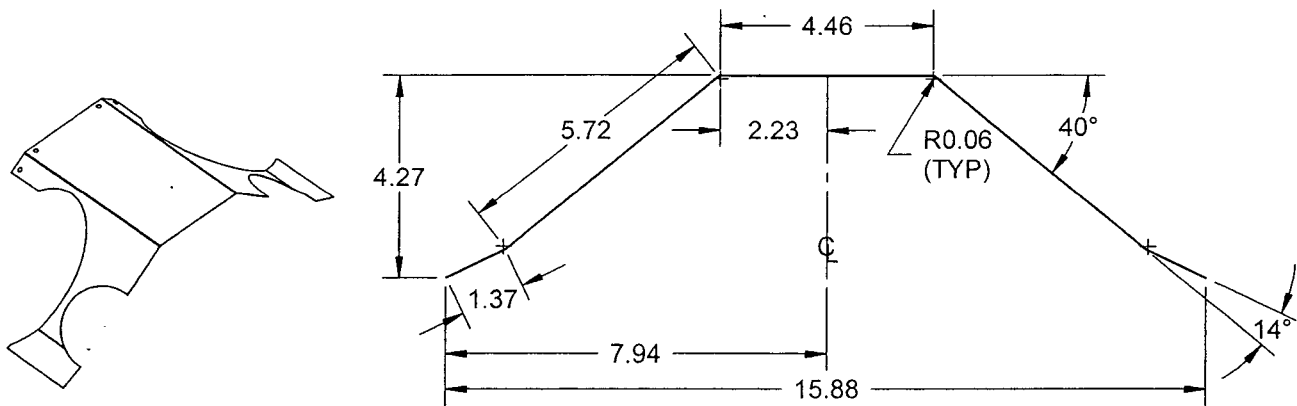
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DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:4



**D3467-17F TOP COVER FLAT PATTERN**



**D3467-17 TOP COVER BENDING DETAIL**

**NOTES:**

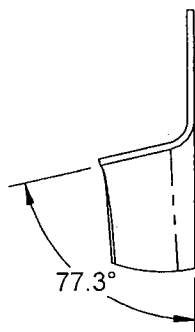
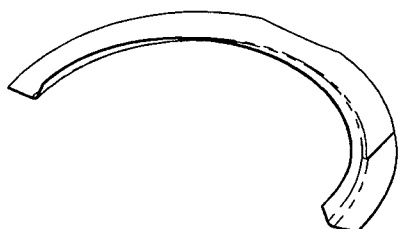
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
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- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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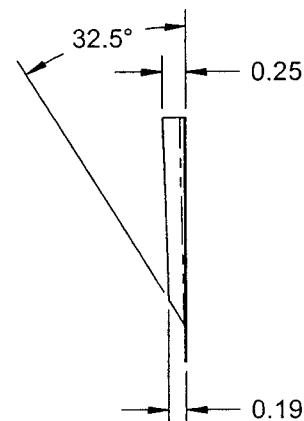
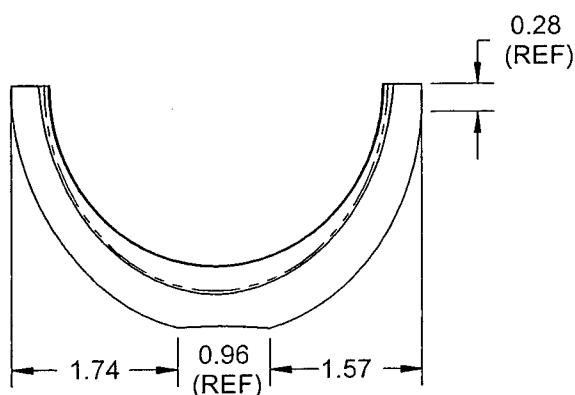
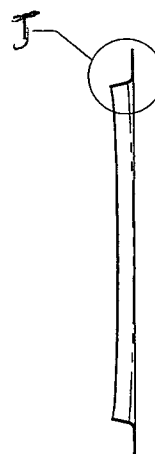
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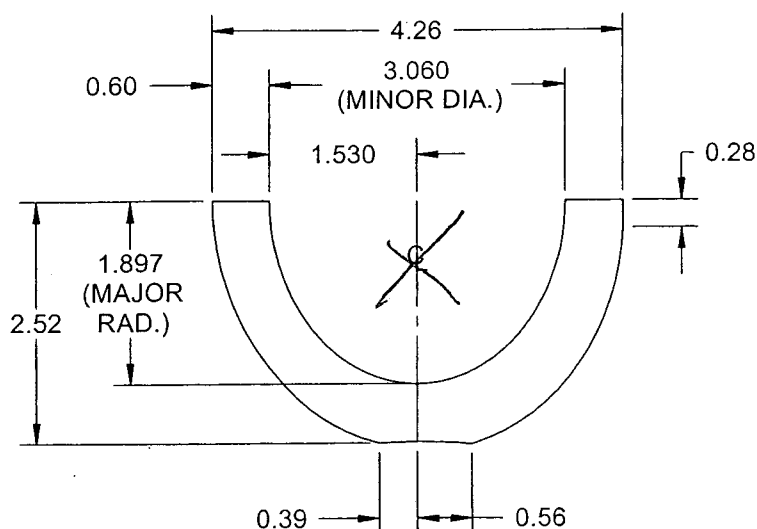
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CHECKED	APPROVED	DRAWING NO. D3467	REV. A SHEET 15 OF 15
DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2



DETAIL J  
SCALE 1:2



**D3467-19 DOUBLER, LH SHOWN**  
**D3467-20 DOUBLER, RH OPPOSITE**



## D3467-19F FLAT PATTERN

### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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